

Work Order ID 155463

Tuesday, January 17, 2017 10:01:08 AM

155463

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Lid Assembly, Long Basket
Start Date: 1/18/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/20/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: **DAS**

Approvals: Process Plan: **21** Date: Tooling: Date: Run Start ***NR1***
QC: **9-89** Date: **JAN 17 2017** SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3915	E

100

Weld per dwg A/R Aluminum rod Batch: **3134826** 0.00
Large Fab

100

Large Fab

Large Fab

Memo

0.38

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

H CC 17-1-25

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

D 17-01-26 **DAS**
9
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :	Step #:	QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				Completed By	
						Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
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Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① 17-01-26

DAS
9
9-99

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.15

Hand Finishing

ENSURE TO RINSE CAREFULLY ACID AND ALODINE

X1

2017/01/26
BEB

140

Weld per dwg A/R Aluminum rod Batch: 134826

0.00

140

Large Fab

Memo

0.09

Large Fab

1- weld (4) corners

1 JAN 30 2017

Gpc

DQA: _____ Date: _____



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150									
QC	Memo	0.00							
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							
155									
QC	Memo	0.00							
Quality Control									
	inspect fit of lid with base								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
157									
HandFinish	Memo	0.14							
Hand Finishing	1- realodine corners ***do not acid etch***								

① 17-01-30 ①

① 17-01-30 ①

① ① 201702101
BEB.

DQA: _____ Date: _____



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Run Hours

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Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00

160

Powdercoat

Memo

0.03

Powder Coating

1- touch up corner with alodine only
2- Plug holes prior to

1ST COAT:

START TIME: 10:05OVEN TEMPERATURE: 325FINISH TIME: 10:35

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 Ø 17-02-1 25 34 38

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

1 x d all 17/02/01 DAS 15 9-89

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Qty****Reject
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Stamp**

180

Assemble as per dwg

0.00

180

HandFinish

Memo

0.19

Hand Finishing

1- Install webbing as per dwg

2- Install placard and label as per dwg

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: W/O

0.00

200

Packaging

Memo

0.00

Packaging

124272-014 / 13154934

DAS
38
3-00
FEB 03 2017

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Tuesday, January 17, 2017 10:01:08 AM

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17/2/87

FEB 06 2017

Picklist Print

Tuesday, January 17, 2017 10:01:13 AM

Page 1

Work Order ID: 155463

155463

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 1/18/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957		Manufactured	No			100	Each	25.0000	4	4			
D2957									**				
Mounting Plate													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			25					
					138993			25					
D3915-1		Manufactured	No			100	Each	6.0000	2	2			
D3915-1									**				
Rib													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			6					
					151022			6					
D4016-5		Manufactured	No			100	Each	42.0000	3	3			
D4016-5									**				
Hinge Half, Light Lid													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA004			42					
					137225			7					
					152120			35					

CC 17-1-24

4x

CC 17-1-24

2x

CC 17-1-24

3x

Picklist Print

Page 2

Tuesday, January 17, 2017 10:01:13 AM

Work Order ID: 155463

155463

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 1/18/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

D4019-3
D4019-3
 Rib

Manufactured No

100

Each

13.0000

3

3

**

CC 17-1-24

Location

Loc Qty

Loc Code

WA004

13

144402

1

154037

12

Manufactured No

100

Each

2.0000

2

2

**

CC 17-1-24

Location

Loc Qty

Loc Code

WA004

2

149890

2

Manufactured No

100

Each

6.0000

1

1

**

CC 17-1-24

Location

Loc Qty

Loc Code

WA004

6

120216

6

Manufactured Yes

180

Each

-1.0000

1

1

**

22 1x 2x 17/01/17

D2728-1
D2728-1
 Dart Logo Label Small

Manufactured No

180

Each

3.0000

1

1

**

D4029-041
D4029-041
 Webbing (Long Basket)

Location

Loc Qty

Loc Code

ST498A

3

149654

3

DAS
 9-89 FEB 01 2017

Picklist Print

Tuesday, January 17, 2017 10:01:13 AM

Work Order ID: 155463

155463

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 1/18/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W4

Purchased

No

180

Each

1,409.000

34

34

MS20600-AD4W4

Rivet

**

FEB 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

CCK004

1055

M135704

55

M136295

1000

ST308

150

M133990

150

WA003

204

M135442

204

133990

NAS1149DN949J

Purchased

No

180

Each

194.0000

34

34

NAS1149DN949J

Washer

**

FEB 01 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST265

194

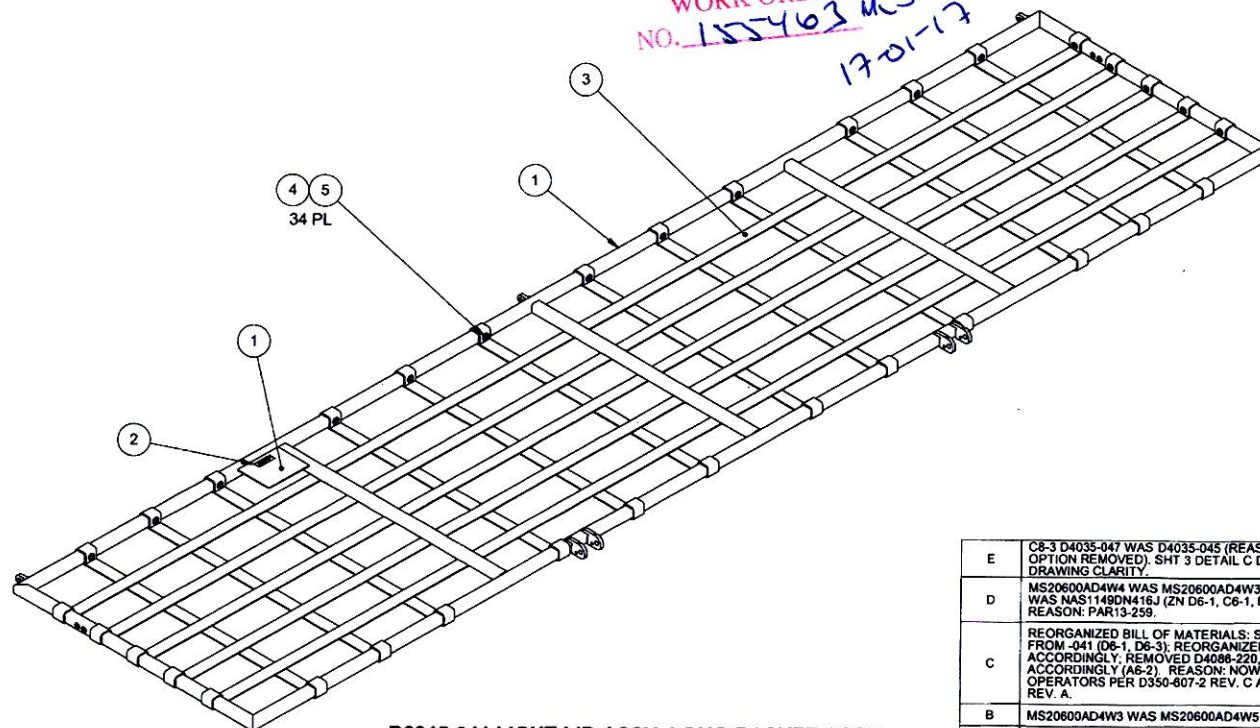
m135058

194

34

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	NAS1149DN949J	WASHER
5	34	MS20600AD4W4	RIVET, BLIND, PAN-HEAD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155463 MJS
17-01-17

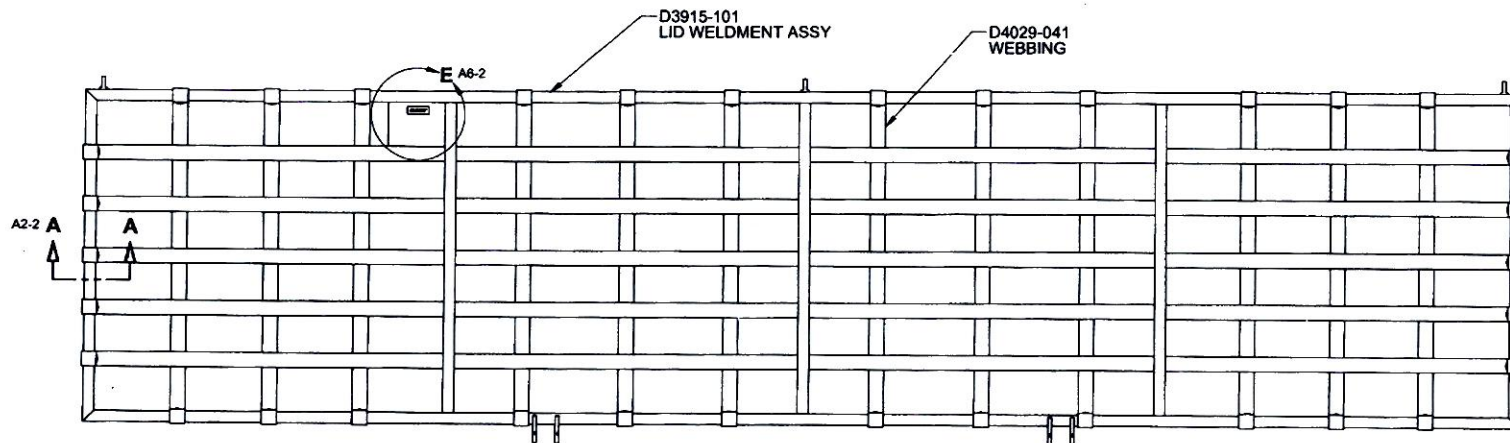


D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

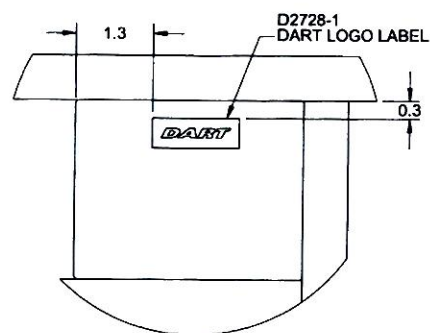
RELEASED
2013-08-16

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: 6.98 lbs

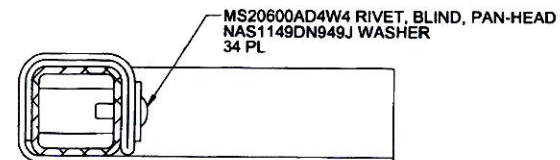
E	C8-3 D4035-047 WAS D4035-045 (REASON PROFORM OPTION REMOVED). SHT 3 DETAIL C DELETED FOR DRAWING CLARITY.	AJS	13.07.18
D	MS20600AD4W4 WAS MS20600AD4W3; NAS1149DN949J WAS NAS1149DN416J (ZN D6-1, C6-1, B1-2). REASON: PAR13-259.	MB	13.06.19
C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY. REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-807-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5 BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 TITLE LIGHT LID ASSY-LONG BASKET SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.07.18		



D3915-041 LIGHT LID ASSY, LONG BASKET



DETAIL E D6-2

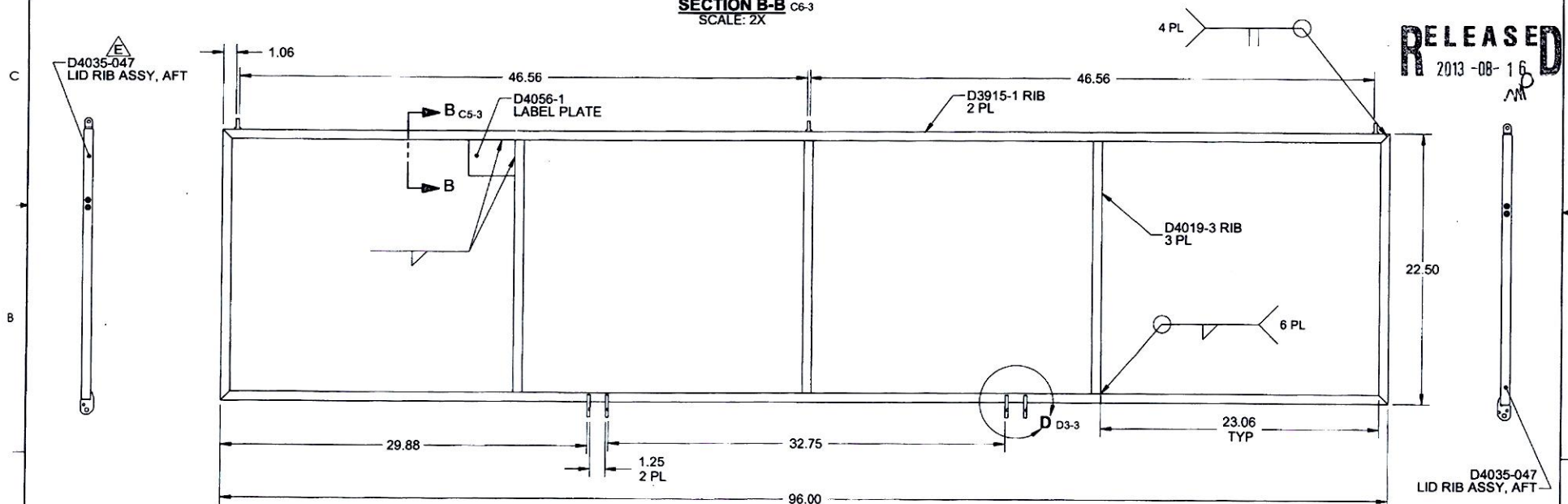
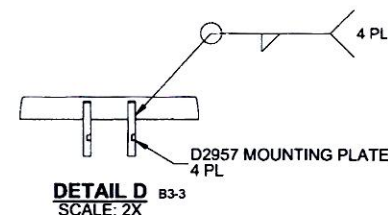
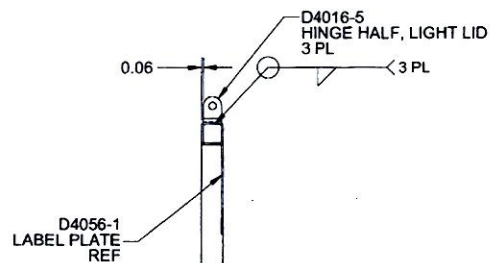


SECTION A-A C8-2
SCALE: 8X

RELEASED
2013-08-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UT	DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	2	D3915-1	RIB
2	4	D2957	MOUNTING PLATE
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	2	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
6	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



D3915-101 BASKET LID WELDMENT ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.82 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKE NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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